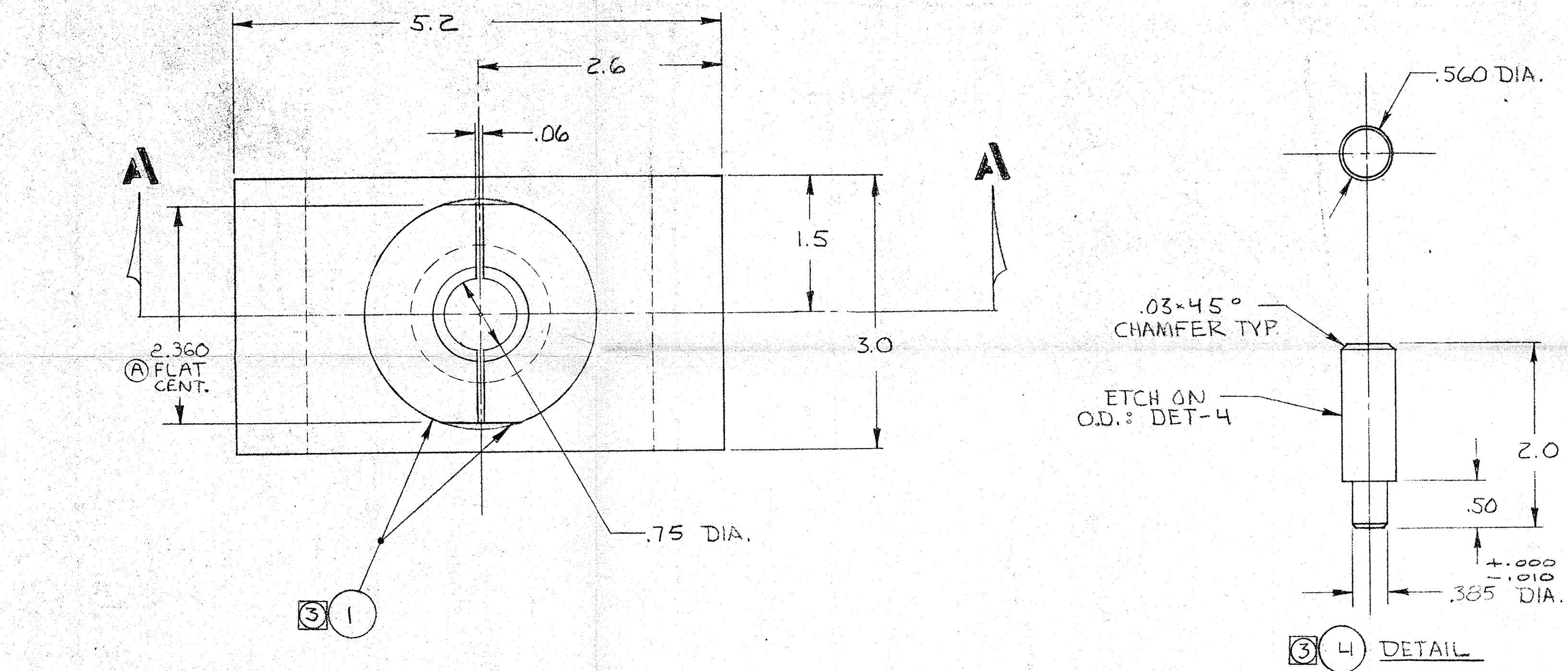
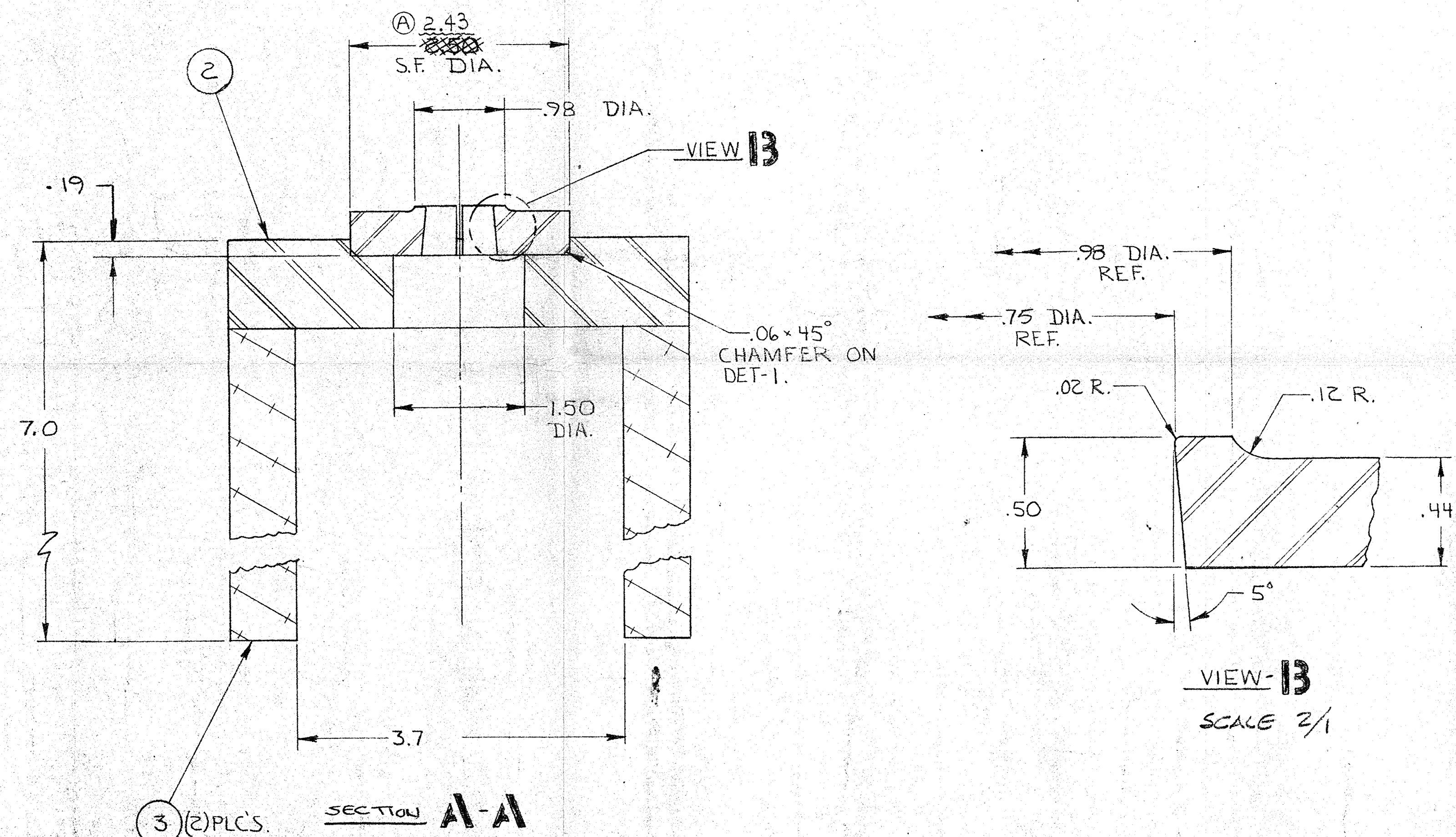


| E.O. NUMBER | CHG. LET. | CHANGE DESCRIPTION | DATE | BY | APP. |
|----------------|-----------|--------------------------------|---------|--------|------|
| T.O. 927890 | N/C | INITIAL RELEASE | 11/9/77 | BW | |
| 942532 | A | ADD 2.360 & 2.43 DIM. WAS 2.50 | 11/80 | D.F. | A. |
| 026041 | B | DET-4 1.385 DIA WAS .409 DIA. | 3/1/83 | L.H.B. | JAY |



TOOL INSTRUCTIONS

1. REMOVE SPLIT RINGS FROM MAIN-BODY OF FIXTURE.
2. INSERT GEARSHAFT (BEARING END FIRST) THRU HOLE FROM BOTTOM OF FIXTURE.
3. INSERT (1) SPLIT RING, WITH RAISED EDGE UP, IN CBORED HOLE BETWEEN BEARING AND GEAR.
4. INSERT OTHER RING IN SAME MANNER AS NO. 3 ABOVE.
5. LET BEARING REST AGAINST BOTH RINGS.
6. PLACE FIXTURE IN ARBOR PRESS PRESS SHAFT FROM BEARING USING DET-4 IN END OF SHAFT.



TOOL FUNCTION:

1. TO REMOVE 369D25418 BEARING FROM 369D25434 GEAR SHAFT ASSY.

NOTES:

1. USE STD. BOLT CONST. WHERE APPLICABLE.
 2. PARK-O-LUBE ALL STL. DETAILS.
- (3) HEAT TREAT 50-59 R/C.

| 830006-806-00674 | | CHG. LET. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|------|---|------------------|----------------------|---------------------------------|----------|----------------------|------|---|---|---|---------------|-------|--|---|---|---|-------------|-------------|--|---|---|---|---------------|--------|--|---|---|---|------------------|----------|--|
| TOOL NUMBER 00674 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <tr> <th>CODE</th> <th>DET.</th> <th>NO. REQ'D</th> <th>MATERIAL</th> <th>SIZE AND DESCRIPTION</th> <th>ZONE</th> </tr> <tr> <td>3</td> <td>4</td> <td>1</td> <td>3/16 DIA. x 2</td> <td>D. R.</td> <td></td> </tr> <tr> <td>3</td> <td>2</td> <td>2</td> <td>3/4 x 3 x 6</td> <td>6061-T6 AL.</td> <td></td> </tr> <tr> <td>2</td> <td>1</td> <td>1</td> <td>1 x 3 x 5 1/4</td> <td>H.R.S.</td> <td></td> </tr> <tr> <td>3</td> <td>1</td> <td>1</td> <td>2 1/2 DIA. x 1/2</td> <td>D-2 T.S.</td> <td></td> </tr> </table> | | | CODE | DET. | NO. REQ'D | MATERIAL | SIZE AND DESCRIPTION | ZONE | 3 | 4 | 1 | 3/16 DIA. x 2 | D. R. | | 3 | 2 | 2 | 3/4 x 3 x 6 | 6061-T6 AL. | | 2 | 1 | 1 | 1 x 3 x 5 1/4 | H.R.S. | | 3 | 1 | 1 | 2 1/2 DIA. x 1/2 | D-2 T.S. | |
| CODE | DET. | NO. REQ'D | MATERIAL | SIZE AND DESCRIPTION | ZONE | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | 4 | 1 | 3/16 DIA. x 2 | D. R. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | 2 | 2 | 3/4 x 3 x 6 | 6061-T6 AL. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | 1 | 1 | 1 x 3 x 5 1/4 | H.R.S. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | 1 | 1 | 2 1/2 DIA. x 1/2 | D-2 T.S. | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p align="center">Hughes Helicopters TOOL DESIGN DEPT.</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>TITLE: BEARING SEPARATOR 369D25418 BEARING, T. ROTOR</p> | | | | | <p>ENG. CHANGE B</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>DRAWN B. WEBER 11-9-77</p> | | <p>TOLERANCES UNLESS OTHERWISE SPECIFIED</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>CHECKED H. WEBER 11-9-77</p> | | <p>DECIMAL .XX ±.01</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>APPROVED H. WEBER 11-15-77</p> | | <p>DECIMAL .XX ±.03</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>SHEET NO. 1 OF 1</p> | | <p>SCALE FULL</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <p>ENGINEERING PART REF. NO. 369D25418</p> | | <p>TOOL DRAWING NUMBER 830006-806-00674</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |